SK A45-O

open arc metal cored wire

Classifications

DIN 8555

MF 10-GF-65-GT

Characteristics

Chromium-Niobium-Molybdenum alloy with addition of Tungsten and Vanadium designed to resist high stress grinding abrasion with low impact and solid erosion at service temperatures up to 650 °C. The deposits will readily show stress relief cracks.

Microstructure:	Austenitic matrix with hexagonal primary and eutectic carbides and nodular Nb carbides with complex combined carbides
Oxy-acetylene cutting	Cannot be flame cut
Machinability	Grinding only
Deposit thickness	8 to 12 mm in 2 or 3 layers

Field of use

Wear plates, sinter finger crushers, exhaust fan blades in pellet plants, perlite crushers, bucket teeth and lips on bucketwheel excavators, boiler fan blades, burden area in blast furnace bells, etc.

Typical analysis in %

C	Mn	Si	Cr	Mo	Nb	W	V	Fe
5.3	0.2	0.7	21.2	6.3	6.1	1.9	1.0	balance

Typical mechanical properties

Hardness as welded: 63 HRC

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]
1.6	180 – 200	26 – 30	35 – 40
2.0	200 – 250	26 – 30	35 – 40
2.4	250 – 300	26 – 30	35 – 40
2.8	300 – 350	26 – 30	35 – 40